

Date: Tuesday, 28/10/2008 3:44:27 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT ASS'Y RH		
Job Number	: 43045			Part Number	: D412769044		
Estimate Number	: 13314			Drawing Number	: D412-769-2 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 28/10/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 20/11/2008 Qty: 1 Um: Each		
Previous Run	: 43044						
Written By	:						
Checked & Approved By	: JUL 08 / 10.29						
Comment	: Est rev A 08-05-12 new issue DD verified by:ec Est Rev:B 08-07-17 revB as per dwg DD verified by:ec Est Rev:C 08-08-21 move D3792-1 after powder coat DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
2.0	D3782045	Back Leg Assembly	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Back Leg Assembly batch: B42830 *		
3.0	D3782041	Front Inboard Leg Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Inboard Leg Assembly batch: 42149		
4.0	D3782044	Front Outboard Leg Assembly, RH	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Outboard Leg Assembly, RH batch: 42151		
5.0	D3783041	Lateral Brace Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lateral Brace Assembly batch: 42725		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 43045

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D3783043

Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly
batch: _____

B42847

SS 08/12/18 X

7.0 D3783045

Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly
batch: _____

42551

SS 08/12/18 X

8.0 D3784041

Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center
batch: _____

B42641

SS 08/12/18 X

9.0 D3784043

Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH
batch: _____

42520

SS 08/12/18 X

10.0 D3784044

Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH
batch: _____

42520 2

SS 08/12/18 X

11.0 D37662

Front Rail, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail
batch: _____

40864

SS 08/12/18 X

12.0 D37663

Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail
batch: _____

40865

SS 08/12/18 X

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 43045

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D37671 Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: 40866

JS 08/12/18 (X)

14.0 AN415A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108868

JS 08/12/18 (X)

15.0 AN45 13A EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M109712

JS 08/12/18 (X)

16.0 AN510A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M109282 X4 M10703 X2

JS 08/12/18 (X)

17.0 AN513A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M109746

JS 08/12/18 (X)

18.0 AN960JD10 Washer



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M109461

(or NAS1149D0363J) batch:

JS 08/12/18 (X)

19.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M109249

(or NAS1149D0463J) batch:

JS 08/12/18 (X)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 43045

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0 AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

M109752

batch:

(or NAS1149D0568J) batch:

AS 08/12/18 (X)

21.0 AN52510R24

Screw



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

M108879

batch:

AS 08/12/18 (X)

22.0 MS21042L3

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

M108816

batch:

AS 08/12/18 (X)

23.0 MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

M108145

batch:

AS 08/12/18 (X)

24.0 MS21042L5

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

M109297

batch:

AS 08/12/18 (X)

25.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

FF 08/12/18 (X)

26.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/18 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 43045

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

27.0 POWDER COATING

POWDER COATING



M109648



1X

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- install bolts in 3 place (in seat belt eye bolt holes) to ensure leg does not move when powder coating

3- Powder coat remainig of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

1-45-01

OVEN TEMPERATURE:

329°

FINISH TIME:

2-15

ML 08/12/18

28.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

29.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0 D37921

Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

41879

FF 08/12/19

①

31.0 D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard

batch:

42875

FF 08/12/19

①

32.0 D37741

Seat Bottom, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH/RH

batch:

41084

FF 08/12/19

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT FACING SEAT ASS'Y RH
Job Number: 43045		Part Number: D412769044
Job Number:		
Seq. #:	Machine Or Operation:	Description :
33.0	D37743	Seat Back, LH/RH
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH R.H batch: B 41085		FF 08/12/19 (1)
34.0	AN525 10R22	Screw
Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Screw batch: 108879 x 9 / M109238 x 4		FF 08/12/19 (1)
35.0	AN960JD10L	Washer
Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Washer batch: 105793 (or NAS1149D0332J) batch:		FF 08/12/19 (1)
36.0	MS21042L3	Nut
Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s) Nut batch: M108816		FF 08/12/19 (1)
37.0	AN35A	Bolt
Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt batch: M100188		FF 08/12/19 (1)
38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- install remaining parts as per dwg D412-769-2		FF 08/12/19 (1)
39.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		S 08/12/19 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 43045

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

40.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD42988

JS 08/10/23 (x)

41.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



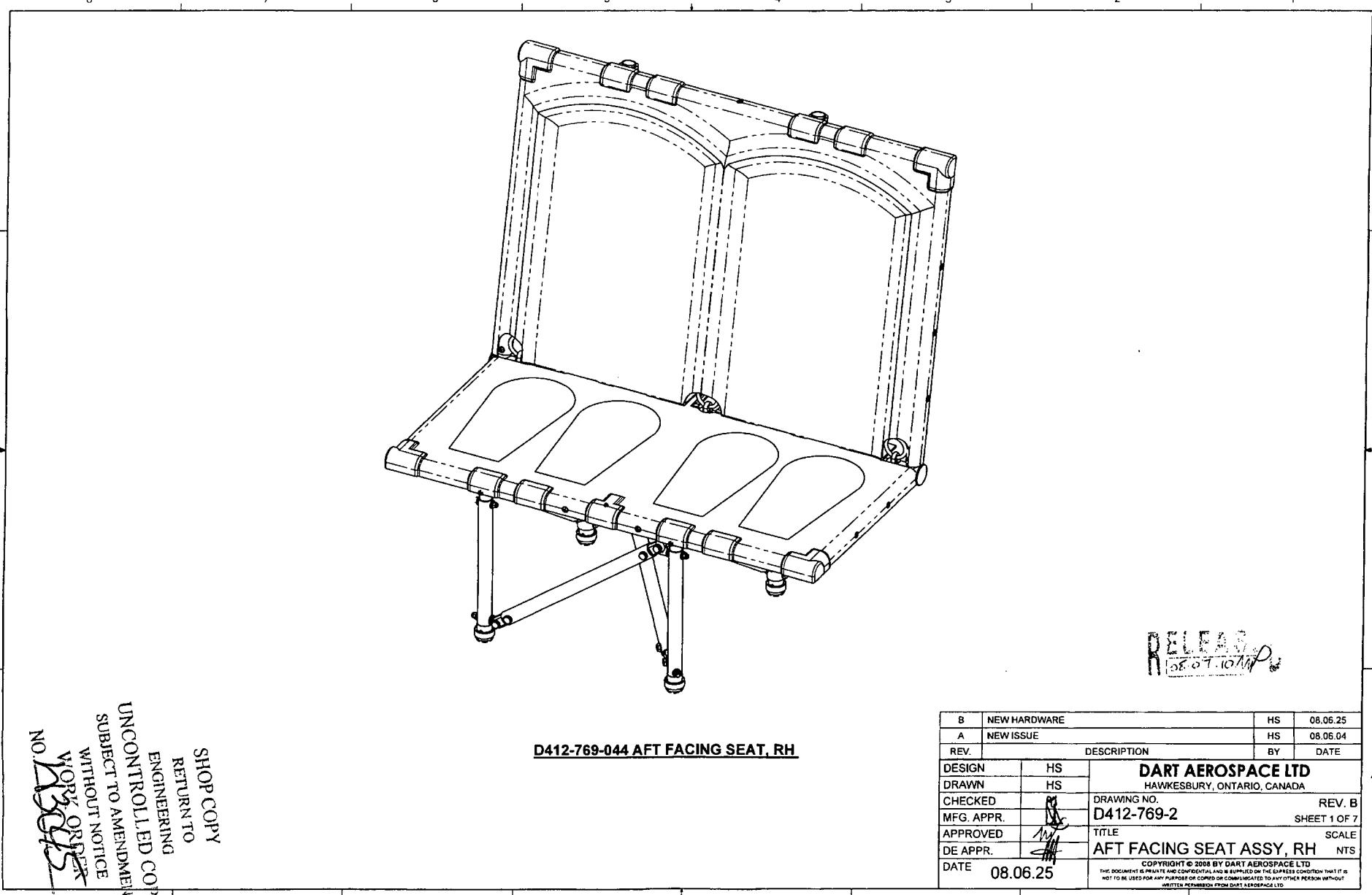
U 08/12/24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

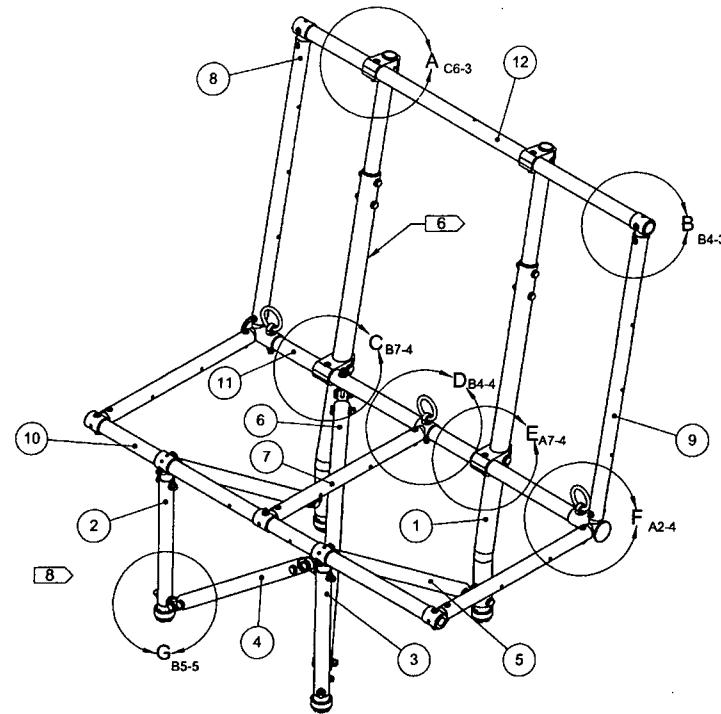


8 7 6 5 4 3 2 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-2	FRONT RAIL, RH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

NO. 123075
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 WORK ORDER
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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART OSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3). MASK FRONT LEGS PRIOR TO POWDER COAT
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
 - 7) WEIGHT: 30.0 lbs
 - 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

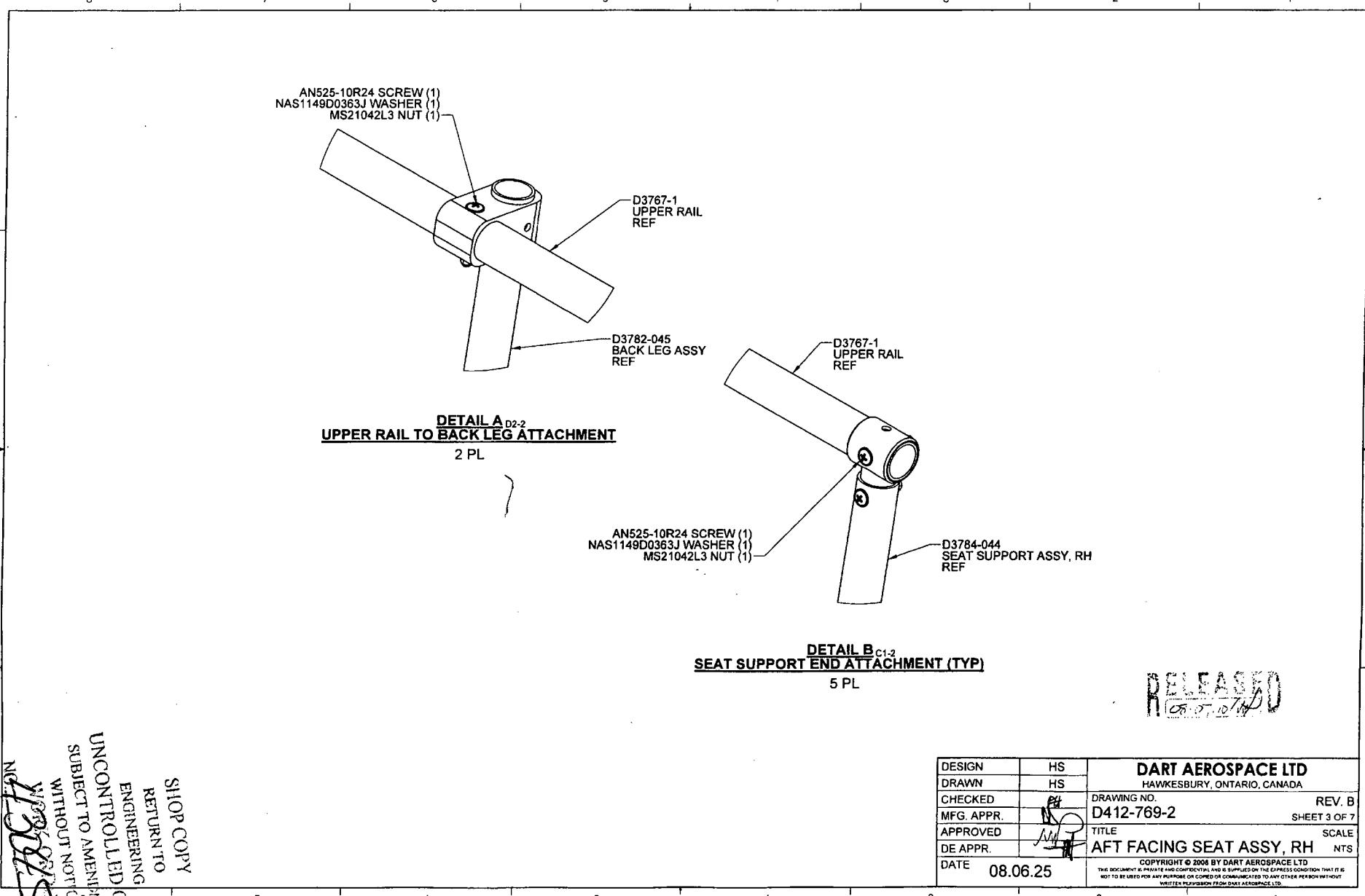


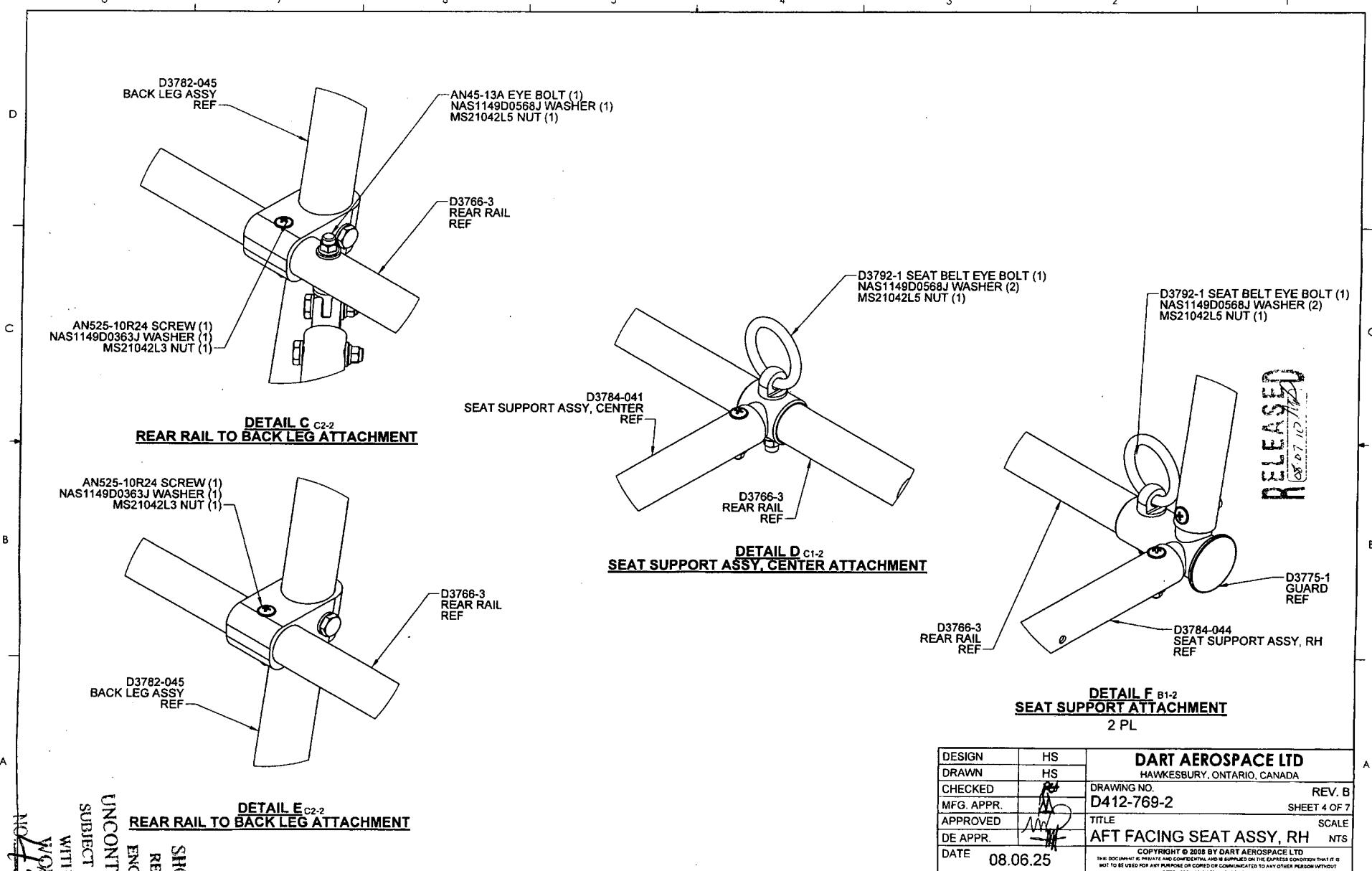
D412-769-044 AFT FACING SEAT, RH

RELEASED
08-07-10

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	DRAWING NO.	
MFG. APPR.	✓	REV. B	
APPROVED	✓	SHEET 2 OF 7	
DE APPR.	✓	TITLE	
DATE	08.06.25	SCALE	
AFT FACING SEAT ASSY, RH NTS			

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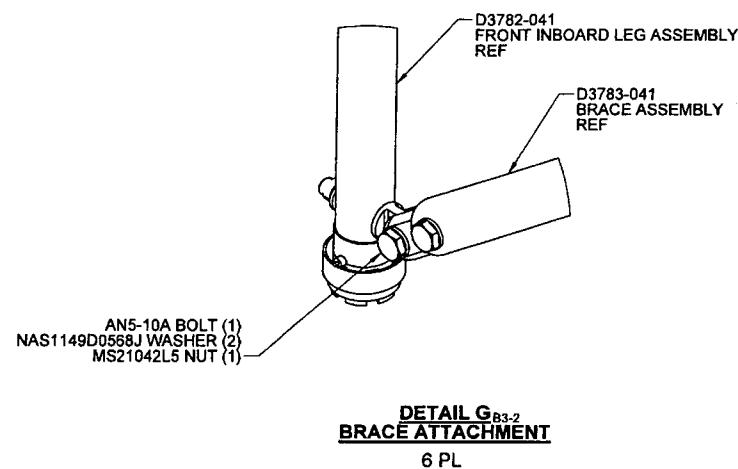
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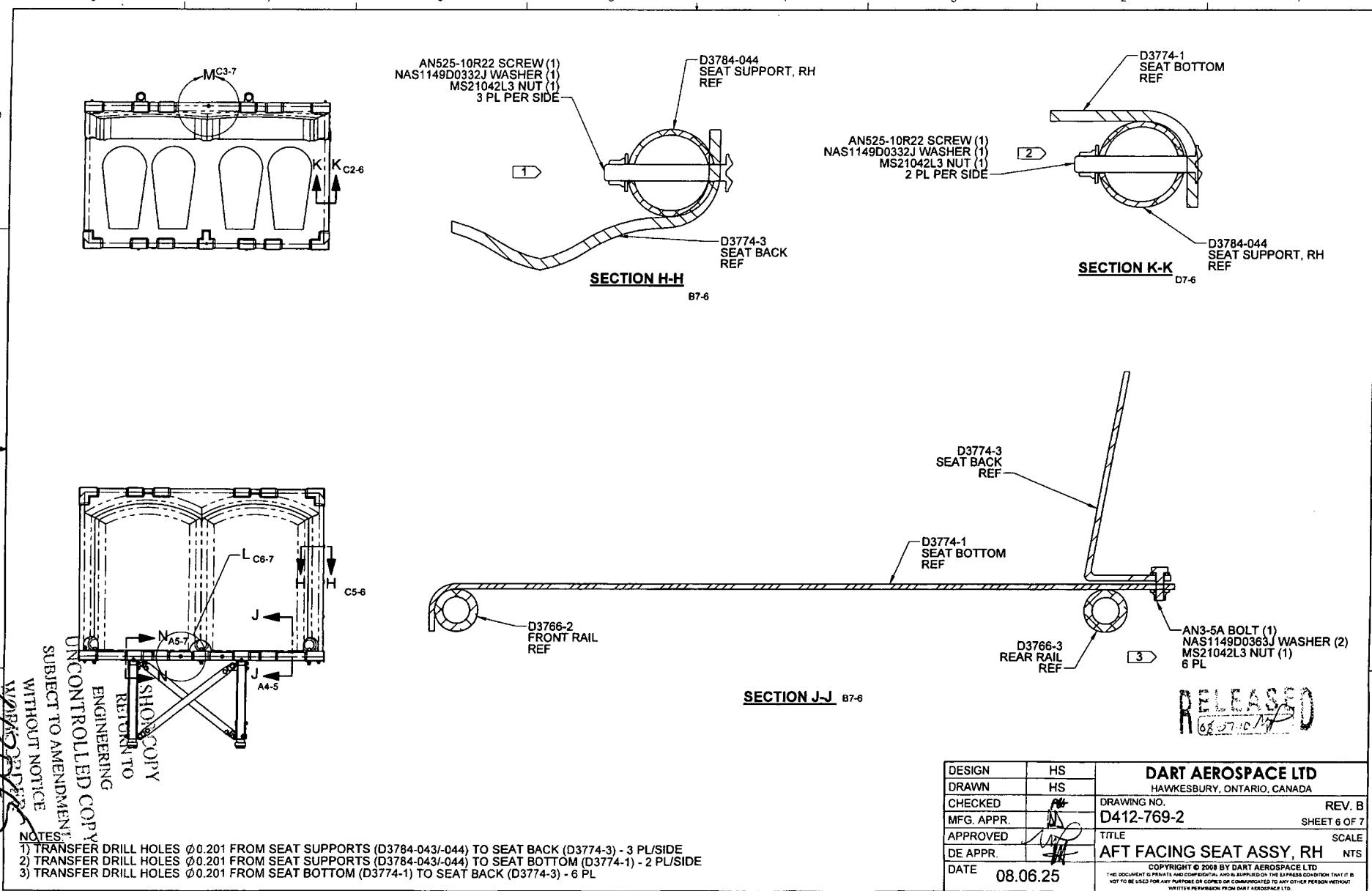
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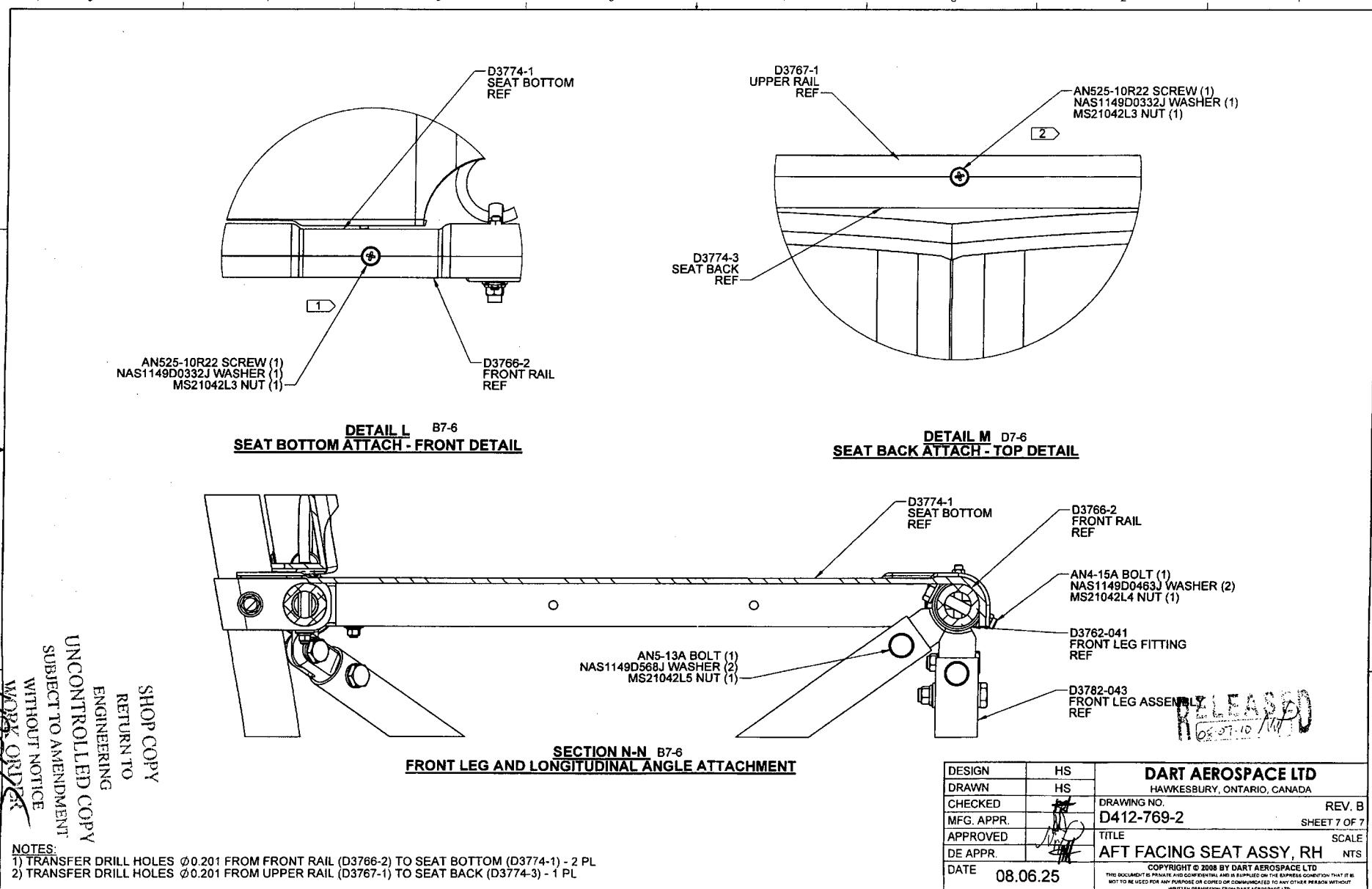
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10-17-2014

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DRAWN	HS			
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MFG. APPR.	MA	D412-769-2	SHEET 5 OF 7	
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DE APPR.	MA	AFT FACING SEAT ASSY, RH	NTS	
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APPROVED		REV. B
DE APPR.		SHEET 7 OF 7
DATE	08.06.25	TITLE
		AFT FACING SEAT ASSY, RH
		NTS

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